

Work Order ID 152089

152089

Page 1

Wednesday, October 19, 2016 3:28:43 PM

Item ID: PB67-43001-21 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Upper Blade Support And Cover Assembly
 Start Date: 10/14/2016 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 10/19/2016 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: OCT 20 2016 Tooling: _____ Date: _____ Run Start *NR1*
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-21	Rev C								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.12							
Small Fab	Assemble as per dwg PB67-43001								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	Identify as per dwg & Stock Location: <u>ME222</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging	LOCATION: WA003								

2 DG 2016/12/22

② 17.01.05 DAS 9 9-89

2 JAN 05 2017 Cpl

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 152089***152089***

Page 2

Wednesday, October 19, 2016 3:28:43 PM

Item ID: PB67-43001-21

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Upper Blade Support And Cover Assembly

Start Date: 10/14/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/19/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		
130									
QC	Memo	0.03							
Quality Control							DAS 21 9-89		

~~JAN 05 2017~~

JAN 05 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																					
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Picklist Print

Wednesday, October 19, 2016 3:28:43 PM

Page 1

Work Order ID: 152089

152089

Parent Item: PB67-43001-21

PB67-43001-21

Parent Item Name: Upper Blade Support And Cover Assembly

Start Date: 10/14/2016

Required Date: 10/19/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-25 new issue DD verified by:ec
10.09.28 per rev C dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS27039-1-10

Purchased

No

100

Each

522.0000

10

20

MS27039-1-10

SCREW

Location

Loc Qty

Loc Code

GA

17

m129541

17

over006

300

m135774

300

ST280

205

x12

m135603

205

x8

} MF 16-12-02

NAS1149D0316J

Purchased

No

100

Each

1,397.000

10

20

NAS1149D0316J

Washer

Location

Loc Qty

Loc Code

ST264

1397

M134502

1397

MF 16-12-02

NAS1149D0363J

Purchased

No

100

Each

1,354.000

12

24

NAS1149D0363J

Washer

Location

Loc Qty

Loc Code

GA

336

m134055

336

ST263

1018

m134955

58

m135297

9

m135864

951

MF 16-12-02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
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Picklist Print

Wednesday, October 19, 2016 3:28:43 PM

Page 2

Work Order ID: 152089

152089

Parent Item: PB67-43001-21

PR67-43001-21

Parent Item Name: Upper Blade Support And Cover Assembly

Start Date: 10/14/2016

Required Date: 10/19/2016

Start Qty: 2.00

Required Qty: 2.00

PB67-43001-173

Manufactured No

100

Each

4.0000

1

2

PR67-43001-173

Cover Plate

Location

Loc Qty

Loc Code

Mezz2

4

138693

4

mf 16-12-20

PB67-43001-75

Manufactured No

100

Each

0.0000

1

2

PR67-43001-75

Upper Blade Support Ass'Y

PB67-43001-85

Manufactured No

100

Each

1.0000

1

2

PR67-43001-85

D-Pad Assembly, Long

148799 mf 16-12-20

Location

Loc Qty

Loc Code

Mezz2

1

148043

1

mf 16-12-20

B152117 -> ② DG 2017/01/04

DQA: _____ Date: _____



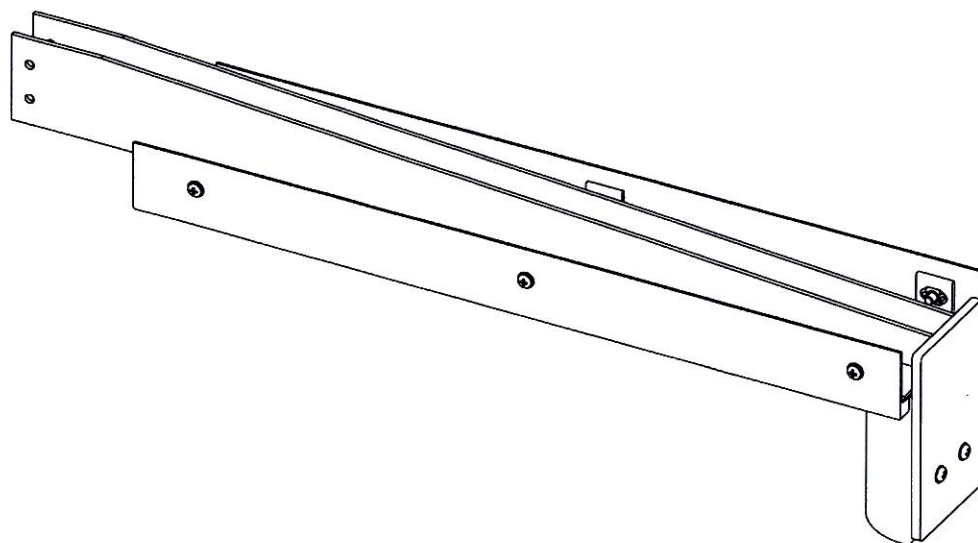
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

ITEM	QTY -21	P/N	DESCRIPTION
1	X	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
3	1	B67-43001-75	LOWER BLADE SUPPORT ASSY
4	1	B67-43001-85	LONG D-PAD ASSY
5	1	B67-43001-173	COVER PLATE
7	10	MS27039-1-10	SCREW
8	10	NAS1149D0316J	WASHER
9	12	NAS1149D0363J	WASHER

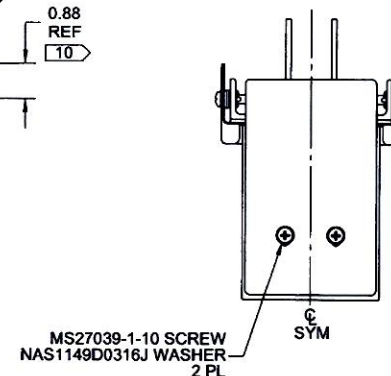
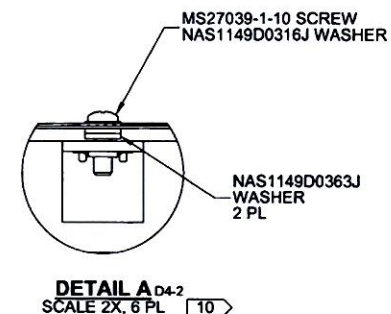
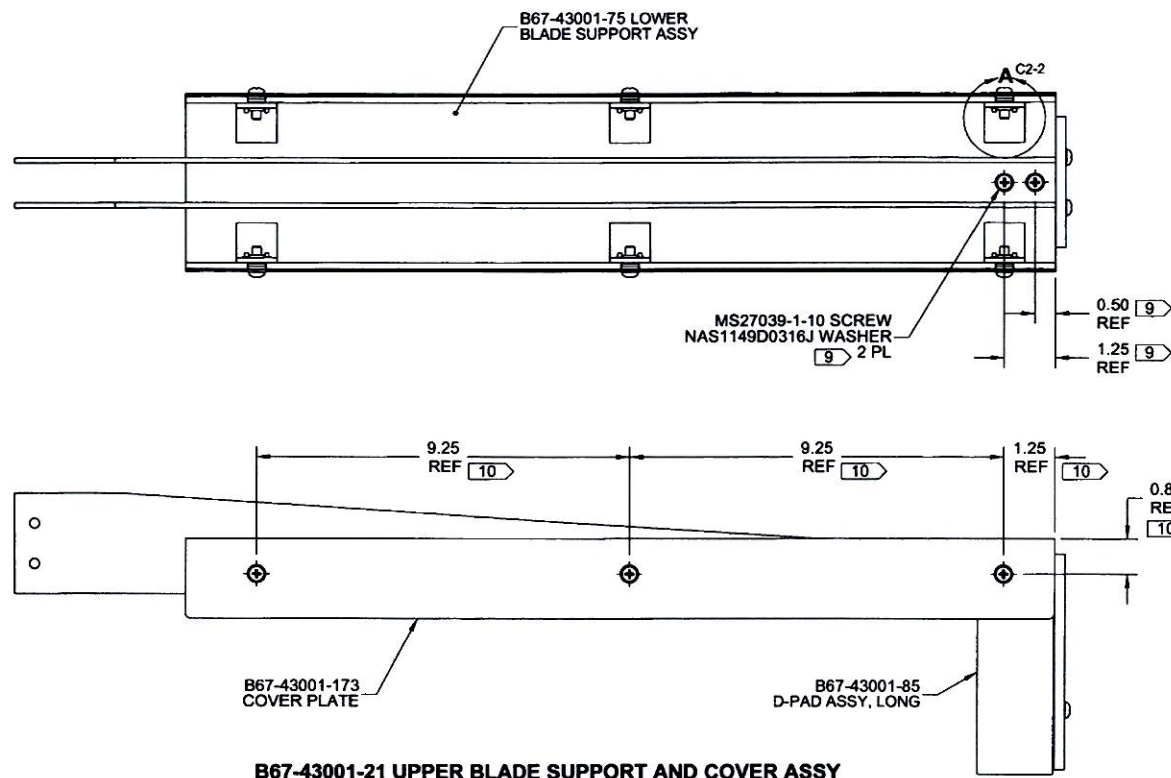


B67-43001-21 UPPER BLADE SUPPORT AND COVER ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152089 MJS
16-10-20

RELEASED
2010-09-16
MP

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 10 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.07.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	AS	DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-21	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.	N/A	UPPER BLADE SUPPORT AND COVER ASSY	NTS	
DATE	09.07.28		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



RELEASED
2010-09-16

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.49 lbs
- 8) WELDING: PER DART QSI 004
- 9) MATCH DRILL $\varnothing 0.250$ THRU B67-43001-173 WITH HOLE PATTERN OF B67-43001-75
- 10) MATCH DRILL $\varnothing 0.250$ THRU B67-43001-173 WITH HOLES IN ANGLE BRACKETS ON B67-43001-75

DESIGN	R/W	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		B67-43001-21	SHEET 2 OF 2
APPROVED	AD	TITLE	SCALE
DE APPR.	N/A	UPPER BLADE SUPPORT AND COVER ASSY	NTS
DATE	09.07.28	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBOD OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			